

Work Order ID 97445

February-19-13 2:56:53 PM

97445

Page 1

Item ID: DSI 9641-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Cargo Door Shim Modification

Stop ***NS2***

Start Date: 2/19/13 Start Qty: 6.00

6

Cust Item ID:

Required Date: 3/26/13 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: *[Signature]*

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9641	A	<i>x SP</i>							
100		0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPP DSI9641-011 CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

B [Signature] MLJ 13-2-25
(6)

P 13/3/11 (6)

B

SM
135.11

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION <div style="display: flex; justify-content: space-around;"> <div style="text-align: right;"> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> </div> <div style="text-align: right;"> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div style="text-align: right;"> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div style="text-align: right;"> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div style="text-align: right;"> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>							
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											

FAULT CATEGORY												
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

Work Order ID 97445

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Page 2

Item ID: DSI 9641-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Cargo Door Shim Modification

Stop ***NS2***

Start Date: 2/19/13 Start Qty: 6.00

6

Cust Item ID:

Required Date: 3/26/13 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP DSI9641-011								
	Location: _____								
140		0.00							
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

Add to 039.799.013
kits per
ECN 13-557

(DAS 06 9-89) 13/3/13

13/3/14

13-03-13

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Picklist Print

February-19-13 2:56:52 PM

Page 1

Work Order ID: 97445

Parent Item: DSI 9641-011

Start Date: 2/19/13

Required Date: 3/26/13

Parent Item Name: Cargo Door Shim Modification

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:B 13.02.19 AS PER ECN13-507 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4761-1 Shim Block	Shm 6	Manufactured	No			110	Each	0.0000	5	6			
AN507-1032R12 Screw	MS246935274 N	Purchased	No			110	Each	0.0000	5	24			
AN507-1032R15 Screw	Shm 6	Purchased	No			110	Each	0.0000	5	24			
NAS1149D0332J Washer	Shm 6	Purchased	No			110	Each	1,041.0000	8	48			

Location

Loc Qty

Loc Code

FP001

94

122973

94

ST294

947

122973

947

MS21042L3

Nut

Purchased

No

110

Each

7,138.0000

8

48

Location

Loc Qty

Loc Code

FP001

3

122141

3

GA

384

122452

384

ST314

268

117885

32

119017

55

119075

138

123265

43

ST506

6483

123900

2483

124291

4000

1123900

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

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DART SERVICE INSTRUCTION

TO AMEND IIN-D139-799 REV. G AND ICA-D139-799 REV. 6

REF. FAA STC: SR02138SE

REF. EASA STC: 10038656

REFERENCE ONLY
Sm

PURPOSE

Agusta AW139 aircraft with 3G5230A02431/3G5230A02531 cargo door hinges installed may require the installation of an additional shim when installing the D4631-1/-2 Striker plates as part of the D139-799-013 Cargo Door Fwd Opening Kit per Section 3.2.2.10 of IIN-D139-799. The purpose of this Dart DSI is to provide the necessary hardware and instructions for the installation of the shim.

PROCEDURE

1. After removing the existing door hinges and the existing 3G5230A02651 shim, position the D4761-1 shim block against the airframe on the inside of the door in the same location as the removed 3G5230A02651 shim as shown in Figure 1 and transfer drill 4x $\varnothing 0.201$ holes from the airframe to the shim block.
2. Position the D4632-1/-2 striker plate, centered between the newly drilled holes so that it will align with the D2586 latch.
3. Mark the position of the D4632-1/-2 striker plate on the D4761-1 shim block.
4. Remove the D4632-1/-2 striker plate and D4761-1 shim block from the aircraft and drill and countersink 4x $\varnothing 0.201$ holes as shown in Figure 2.
5. Deburr and touch up holes with MIL-P-85582 or MIL-P23377 primer.
6. Install D4632-1/-2 striker plate onto D4761-1 shim block using AN507-1032R12 screws, NAS1149D0332J washers and MS21042L3 nuts.
7. Install shim block striker plate assembly onto aircraft using AN507-1032R15 screws, NAS1149D0332J washers and MS21042L3 nuts.
8. Complete the D139-799-013 installation per Sections 3.2.2.11 thru 3.2.2.16 of IIN-139-799.

PART LIST

Note: For customers who already have D139-799-013 at CHG 005 and earlier, procure the DSI 9641-011 kit from Dart. Each DSI 9641-011 Kit provides parts to retrofit 1 x D139-799-013 Kit. These parts have been added to D139-799-013 @ CHG 006 and subsequent.

QTY. -011	PART NUMBER	DESCRIPTION
X	DSI 9641-011	CARGO DOOR SHIM MOD KIT
1	D4761-1	SHIM BLOCK
4	AN507-1032R12	SCREW
4	AN507-1032R15	SCREW
8	NAS1149D0332J	WASHER
8	MS21042L3	NUT

WEIGHT & BALANCE

This DSI has a negligible effect on Weight & Balance

A	NEW ISSUE	RF	13.01.08
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9641	SHEET 1 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CARGO DOOR SHIM MOD	NTS
DATE	13.01.08	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC.	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

Chantal Lavoie

From: Roberto Fuentes
Sent: March 8, 2013 1:45 PM
To: Chantal Lavoie
Cc: Linda Lacelle
Subject: RE: DELIVERY - DART - 19114

Sorry for delay, I check spec is ok, therefore is acceptable. I don't think we need to change DSI for that, because is equivalent part.

Roberto

From: Chantal Lavoie
Sent: March-08-13 10:56 AM
To: Roberto Fuentes
Cc: Linda Lacelle
Subject: FW: DELIVERY - DART - 19114

Hi Roberto,
I add place an order for AN507-1032R12 for your DSI9641 but it has been replace with MS24693S274.
Please advise if it is acceptable.

Thanks
Chantal

From: Laura McClelland [<mailto:lmcclelland@aviall.com>] **On Behalf Of** Toronto Inbound Queue
Sent: March 8, 2013 12:43 PM
To: Chantal Lavoie
Cc: Toronto Inbound Queue (toronto@aviall.com)
Subject: Re: DELIVERY - DART - 19114

Full Description	
Item:	AN507-1032R12-28
Description:	USE MS24693S274-28
<div>Cancel</div>	

Hi Chantal - AN507-1032R12 is replaced by MS24693S274....100 shipped Feb 15 2013 tracking number 7947 7019 4130....sorry did you order more than 100? I have more stock.

Thank you,

Aviall Toronto
1840 Alstep Dr. Unit 5
Mississauga, ON
L5S 1W1

Ph. 905-676-1695
Fax 905-676-9046
Email: toronto@aviall.com

Subject to prior sales.
Subject to MFG price changes.

Any Aviall quote, acknowledgement or acceptance of your purchase order is made subject to Aviall's Terms and Conditions of Sale. You agree that Aviall's Terms and Conditions of Sale replace and supersede your proposed terms and conditions for all purposes and your acceptance of such terms is evidenced by you continuing to go forward with this order after receipt of this stamped notice. Go to www.aviall.com and click on Terms & Conditions for a copy of such terms.

From: Chantal Lavoie <clavoie@dartaero.com>
To: "Toronto Inbound Queue (toronto@aviall.com)" <toronto@aviall.com>
Date: 03/08/2013 11:29 AM
Subject: DELIVERY - DART - 19114

Hi Laura,
Please advise delivery on back order from p/o:19114 for item AN507-1032R12.
Thanks
Chantal